

Date: Tuesday, 01/04/2008 7:52:47 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ESCUTCHEON
Job Number : 38261	
Estimate Number : 13258	
P.O. Number :	Part Number : D37041
This Issue : 01/04/2008 S.O. No. :	Drawing Number : D3704 <del>REDA</del> UNDER REVIEW.
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1	Drawing Revision : <del>A</del> U/R
Previous Run :	Material :
Written By : <u>JLM 08-04-01</u>	Due Date : 08/04/2008 Qty: 3 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 08-04-01 JLM Verified By:DD	

## Additional Product

# PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
-----	--------------------	-------------------------



Comment: Qty.: 0.2625 f(s)/Unit Total : 0.7875 f(s)  
 6061-T6 Bar .75" X 1.5"  
 Batch: M 104326

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW  
 Cut blank 3.00" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA730 Rev: AA & Dwg D3704 Rev: A

2-Deburr per dwg D3704

M.A/m 08/04/03

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

## ENGINEERING APPROVAL

J 06-04-11 (3)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ESCUTCHEON

Job Number: 38261

Part Number: D37041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

N/A

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

N/A

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

108.0604 PROTOTYPE

Job Completion



MF 08-05-16

Change To w/o

#00224A.

# PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

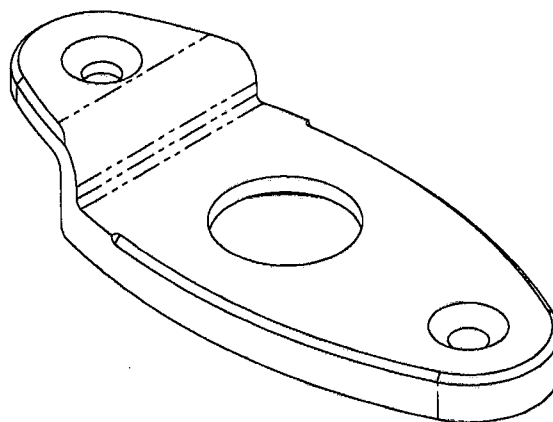
Date: 08.02.06

Product Name: VERTICAL REFERENCE DOOR

Requested By: MB

Design Manager Approval: 

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3701-1F	(FLOOR DOUBLER) FLAT PATTERN	08.02.06	YES	ASAP	SEE BELOW	
1	D3702-1	FORWARD DOUBLER	08.02.06	YES	ASAP	SEE BELOW	
2	D3704-1	ESCUTCHEON	08.02.05	YES	ASAP	SEE BELOW	
						GIVE ALL W/Os AND PARTS TO D. STOW	



**D3704-1 ESCUTCHEON**

**PROTOTYPE**

PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING

**PRELIMINARY ISSUE**

**NOTES:**

1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

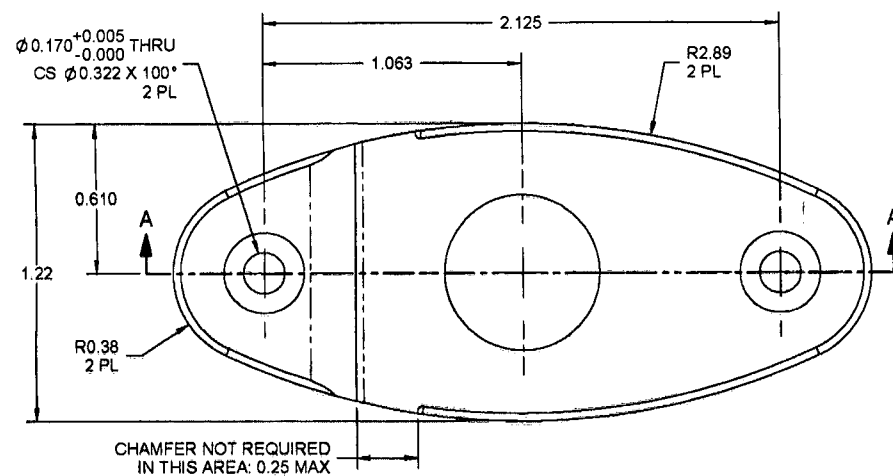
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

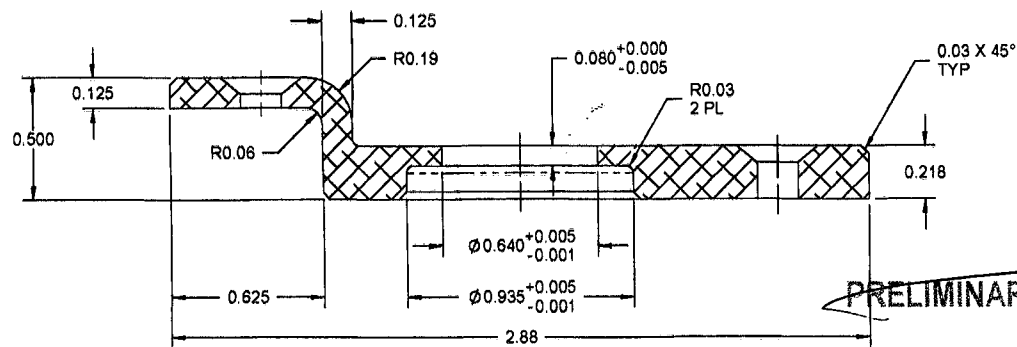
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3704-1" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 0.04 lbs

A		NEW ISSUE		MB	08.02.05
REV.	DESCRIPTION			BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			REV. A	
DRAWN				SHEET 1 OF 2	
CHECKED	DRAWING NO.			REV. A	
MFG. APPR.	D3704			SHEET 1 OF 2	
APPROVED	TITLE			SCALE	
DE APPR.	ESCUTCHEON			NTS	
DATE	08.02.05			COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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**D3704-1 ESCUTCHEON**



**SECTION A-A**

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING

PRELIMINARY ISSUE

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3704	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ESCUTCHEON	NTS
DATE	08.02.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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# Receiving Report

Date: 7/5/07  
Supplier: MAGNA

Batch No: M104326  
Dart P/O: 3436

Packing Slip: Yes ☒ No ☐  
Invoice: Yes ☐ No ☒  
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☐ No ☐ N/A ☒  
Waybill Attached: Yes ☐ No ☒  
Shipment Complete: Yes ☐ No ☒ N/A ☒  
QC6 Inspection ☐ N/A ☒  
Work Order ☐ N/A ☒

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M2024T38080		96	0	0	96	
M6061T6B 0500 X060		12	20	0	8	

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin:

Date

Received/Costing

Initial

07/05/07  
RCR 4320  
[Signature]

Location \_\_\_\_\_

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Sub-Total  
G.S.T.

570.00  
34.20

**TOTAL**

604.20

**FANASIA ALUMINIUM CHINA LIMITED**  
ALUMINIUM CHINA OFFICE  
TEL NO. 36405233

**Customer - Madsen Skolecenter**

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18

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THE  
FEDERAL  
BUREAU OF  
INVESTIGATION  
U. S. DEPARTMENT OF JUSTICE

[illegible]

successful test report

**THE**



50

BT 343-346



# DART

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

## Purchase Order

Date	Page
Mar 28, 2007	1
Purchase Order Number PO00003436	

### Vendor Address:

Magna Stainless  
525 avenue Meloche  
Dorval, QC H9P 2W2  
Canada  
Phone (800) 363-6646  
Fax (514) 631-0013

### Ship To:

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Mar 28, 2007	N30	yours	Mar 30, 2007

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
96.0000	M2024T3S080	2024-T3 .080 sheet Comments: MATERIAL: 2024-T3 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037	3/30/2007	No	13.020000	sf	1,249.92
12.0000	M6061T6B0500X060	6061-T6 Bar .50" x 6.0" Comments: MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 BAR PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 PER AMS-QQ-A-200/8 OR AMS 4160	3/30/2007	No	14.166666	f	170.00
40.0000	M6061T6B0750X015	6061-T6 Bar .75" X 1.5" Comments: AS ABOVE	3/30/2007	No	3.050000	f	122.00
48.0000	M6061T6S080	6061-T6 .080 Sheet Comments: MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027	3/30/2007	No	3.250000	sf	156.00
Tax Summary:							
GST					101.88		
ONT PST					0.00		
Less:							0.00
included tax							
Subtotal							1,697.92
Total tax							101.88
Total purchase order in							
CAD Dollars							1,799.80

Entered By: CL CLAVOIE

Approved By:

**MIL-HDBK-5H**  
1 December 1998

**Table 3.6.2.0(d). Design Mechanical and Physical Properties of 6061 Aluminum Alloy Rolled, Drawn, or Cold-Finished Bar, Rod, and Shapes**

Specification .....	AMS 4116 & AMS-QQ-A- 225/8	AMS 4128 & AMS-QQ-A- 225/8	AMS-QQ- A-225/8	AMS 4117 & AMS-QQ-A- 225/8	AMS 4128 & AMS-QQ-A- 225/8	AMS 4115, AMS 4116, & AMS-QQ-A-225/8
Form .....	Rolled, drawn, or cold-finished rod and special shapes					
Condition .....	T4	T451	T42 <sup>a</sup>	T6	T651	T62 <sup>a</sup>
Cross-Sectional Area, in. <sup>2</sup>	≤50					
Thickness, in. ....	≤8.000	0.500-8.000	≤8.000	≤8.000	0.500-8.000	≤8.000
Basis .....	S	S	S	S	S	S
Mechanical Properties:						
$F_u$ , ksi:						
L .....	30	30	30	42	42	42
$F_y$ , ksi:						
L .....	16	16	14	35	35	35
$F_{cy}$ , ksi:						
L .....	14	14	...	34	34	...
$F_{su}$ , ksi .....	20	20	...	27	27	...
$F_{bru}$ , ksi:						
(e/D = 1.5) .....	48	48	...	67	67	...
(e/D = 2.0) .....	63	63	...	88	88	...
$F_{bry}$ , ksi:						
(e/D = 1.5) .....	22	22	...	49	49	...
(e/D = 2.0) .....	26	26	...	56	56	...
$e$ , percent:						
L .....	18	18	18	10	10	10
$E$ , 10 <sup>3</sup> ksi .....	9.9					
$E_c$ , 10 <sup>3</sup> ksi .....	10.1					
$G$ , 10 <sup>3</sup> ksi .....	3.8					
$\mu$ .....	0.33					
Physical Properties:						
$\omega$ , lb/in. <sup>3</sup> .....	0.098					
$C$ , $K$ , and $\alpha$ .....	See Figure 3.6.2.0					

a Design allowables were based upon data obtained from testing samples of material, supplied in the O or F temper, which were heat treated to demonstrate response to heat treatment by suppliers.